

Date: Tuesday, 19/08/2008 4:03:46 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DECK PLATE,FWD ,350 LITTER KIT
Job Number	: 41423		
Estimate Number	: 11104		
P.O. Number	:	Part Number	: D2364
This Issue	: 19/08/2008 S.O. No. :	Drawing Number	: D2364 REV.F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 39239	Material	:
Written By	:	Due Date	: 08/09/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>JUL 08.8.9</u>		
Comment	: EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.6792 sf(s)/Unit Total : 4.0755 sf(s)  
 2024-T3 .063 Aluminum sheet  
 (M2024T3S063)  
 Batch: 108415 IB 8-8-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2364  
 Dwg Rev: F  
 Prog Rev: F

IB 8-8-22

⑦

2-Deburr if necessary IB 8-8-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/09/23 ⑦

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D2364

08/09/23 ⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:03:46 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 41423

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- deburr if necessary

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/09/23 (X7)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-l

08/09/26

8.0

POWDER COATING

POWDER COATING



M105642



(7X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:10 OF

OVEN TEMPERATURE:

320

FINISH TIME:

8:40

m-l

08/09/27

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 8/9/29

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 186

P P

8/9/29

(7)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41423
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b> D2364
<b>Inspection Dwg:</b> D2364	<b>Rev:</b> F	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.631	*			
Ø0.171	+0.005/-0.000	172	*			
0.354	+/-0.010	356	*			
11.242	+/-0.010	11.247	*			
3.031	+/-0.010	3.035	*			
1.903	+/-0.010	1.905	*			
1.128	+/-0.010	1.129	*			
0.354	+/-0.010	357	*			
1.340	+/-0.005	1.347	*			
2.326	+/-0.010	2.329	*			
3.312	+/-0.010	3.317	*			
4.298	+/-0.010	4.298	*			
5.284	+/-0.010	5.284	*			
6.151	+/-0.010	6.155	*			
6.270	+/-0.010	6.273	*			
0.354	+/-0.010	356	*			
3.031	+/-0.010	3.035	*			
Ø0.656	+0.005/-0.000	657	*			
5.003	+/-0.010	5.003	*			
4.605	+/-0.010	4.606	*			
1.776	+/-0.010	1.778	*			
0.980	+/-0.010	983	*			
4.487	+/-0.010	4.488	*			
7.192	+/-0.010	7.195	*			
7.567	+/-0.010	7.567	*			
7.942	+/-0.010	7.950	*			
Ø0.191	+0.005/-0.000	193	*			
Ø0.197	+0.005/-0.000	198	*			
11.145	+/-0.010	11.145	*			
12.181	+/-0.010	12.181	*			
11.378	+/-0.010	11.378	*			
11.776	+/-0.010	11.776	*			
12.173	+/-0.010	12.173	*			
4.690	+/-0.010	4.695	*			
0.250	+0.005/-0.000	251	*			
3.141	+/-0.010	3.149	*			
0.171	+0.005/-0.000	173	*			

<b>Measured by:</b> RB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-8-26	<b>Date:</b> 08/06/25	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD [Signature]	[Signature]

